

Work Order ID 151946

Friday, October 14, 2016 1:55:49 PM

151946

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Item ID: D3847-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearpad

Start Date: 10/19/2016 Start Qty: 10.00

10

Cust Item ID:

Required Date: 10/24/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: DAS 21 Date: OCT 17 2016 Tooling: _____ Date: _____
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3847	D								

100

0.00

100

Waterjet

Memo

0.10

FLOW CNC Waterjet

1-Cut as per Dwg D3847

Dwg Rev: 3Prog Rev: D

2-Deburr if necessary

(12)

pc 10/10/22

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.02

Quality Control

(12)

pc 10/10/22

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Item ID: D3847-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearpad
Start Date: 10/19/2016 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 10/24/2016 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.03				<u>12</u>			DAS 38 9-89 OCT 17 2016
130 *130* Brake NC Brake NC	Memo Form as per dwg	0.03 0.13			DAS 30 9-89	<u>12</u>			OCT 27 2016
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.03				<u>12</u>			DAS 38 9-89 OCT 28 2016

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Item ID: D3847-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearpad
Start Date: 10/19/2016 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 10/24/2016 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* autoweld 1 Automated Welding 1	Weld per dwg & QSI004 4.5 Memo Weld hardcoat as per dwg A/R 8259 Batch: <u>14135057</u>	0.00 0.13				<u>12</u>	<u>02</u>	<u>16/11-3</u>	
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.03				<u>12</u>			DAS 38 NOV 03 2016
170 *170* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.03				<u>12</u>			DAS 38 NOV 03 2016

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Item ID: D3847-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Wearpad

Stop ***NS2***

Start Date: 10/19/2016 Start Qty: 10.00

10

Cust Item ID:

Required Date: 10/24/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.17							
Quality Control									

DAS
21
9-89

NOV 17 2016

Picklist Print

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Work Order ID: 151946

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Parent Item: D3847-1

D3847-1

Parent Item Name: Wearpad

Start Date: 10/19/2016

Required Date: 10/24/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP RevA: New issue DD verified by:EC
14.11.25 AS PER DWG REV.C DD VERF:JLM IPP REV:C 16.03.31
AS PER DWG REV.D DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	94.8700	0.1236	1.301053			

M304S16GA

304/316 Sheet .063

ex 116/10/22

Location

Loc Qty

Loc Code

MAT010

94.87

m135377

28.42

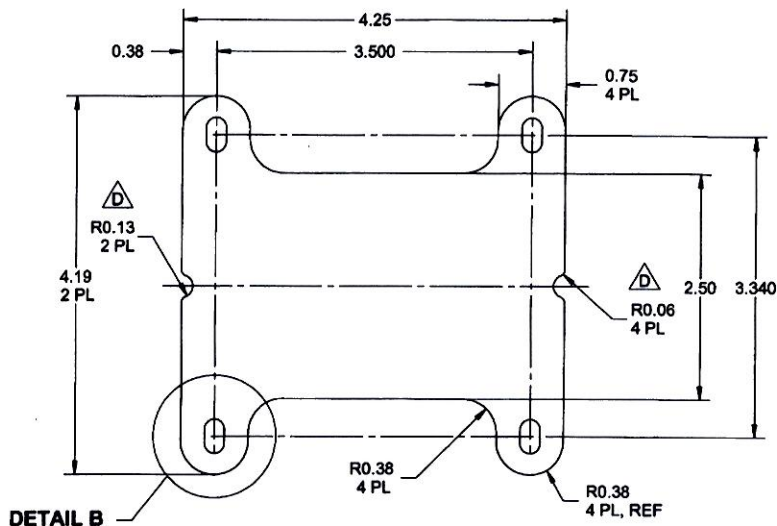
m135559

2.45

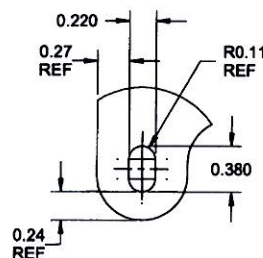
m135689

64

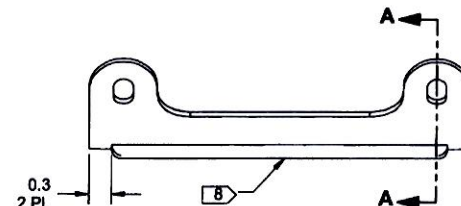
1.7



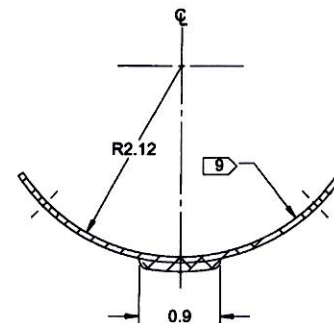
D3847-1F WEARPAD
(FLAT PATTERN)



DETAIL B
4 PL
SCALE 2X



D3847-1 WEARPAD
(MAKE FROM D3847-1F)



SECTION A-A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 151946 MJS
16-05-17

NOTES:
1) MATERIAL -1F: AISI 304/316 STAINLESS STEEL 16 GAUGE 0.063 THICK
PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC. M304S16GA

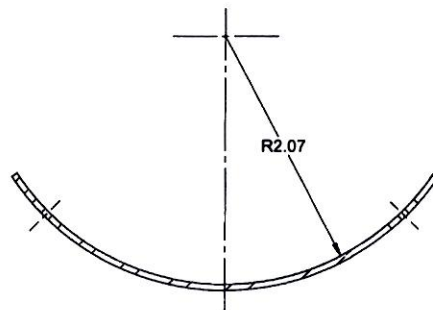
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 0.23 lbs

8) BUILDUP HARD SURFACING 0.17 TO 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR
BUILDUP HARD SURFACING 0.19 TO 0.25 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)
9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING 0.02-0.04 THICK PER DART QSI 005 4.9

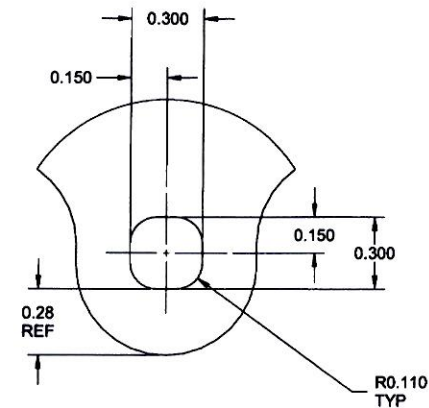
RELEASED
2016-03-31
EN 16-554

APPROVED

D	UPDATE NOTES FOR AUTOMATED WELDING. UPDATE CURRENT DRAWING STANDARDS AND TOLERANCES. REMOVE FINISH. ADD TEXTURED COATING NOTE. UPDATE MATERIAL NOTES. -3F, -5F, -7F & -9F SIDE VIEW REMOVED. 3B7, 7B2, 7B1 REMOVED 0.080 DIMENSION. DB1, DB1, 8C7, 8C5, R0.13 TOOLING NOTCHES ADDED ACCORDINGLY 8C2, 0.2 DIM WAS 0.05 (MANUFACTURING REQUEST).	AJS	15.09.28
C	REMOVED D3846-3I-5I-7I-9 GASKETS, ZN D2-1, ADDED TEXTURED COATING, ZN B3-1. UPDATED WEIGHTS, ZN C3-1/A-B-2	AK	14.08.06
B	CORRECT TYPO D3847-047 WAS D3847-045. ZN B5-1; 5.82 WAS 8.25 (ZN A4-2); 45.28 WAS 45.71 (ZN B4-5)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	AJS		
CHECKED	ML	DRAWING NO.	REV. D
MFG. APPR.	DD	D3847	SHEET 1 OF 7
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
DATE	15.09.28	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



SECTION C-C
SCALE 4X
C3-2
C4-3
C3-4
C2-5



DETAIL D
SCALE 4X
B5-2
B6-3
B3-4
B4-5

RELEASED
2016-03-31

APPROVED

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	AJS	EUGENE, OR	
CHECKED	ML	DRAWING NO.	REV. D
MFG. APPR.	DD	D3847	SHEET 7 OF 7
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